

Tuesday, 28/08/2007 11:53:01 AM

Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D2410	
Job Number	: 34284		Part Number	: D2410	
Estimate Number	: 10804		Drawing Number	: REWORK	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 28/08/2007	S.O. No. : N/A	Drawing Revision	: N/A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 04/09/2007 Qty: 2 Um: Each	
Previous Run	: 00015				
Written By					
Checked & Approved By					
Comment					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 DISASSEMBLE D206-571-043 ASS'Y B/N 26886		FF 07-10-16 2
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 disassemble D2410 assembly as follows: -remove D2403 outer skin -D2375-3-08-106 insulation -D2416 angle -D2411		FF 07-10-16 2
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 -Pick 12x MS20600AD4W4 rivets B <u>H105792</u> (7a)		FF 07-10-16 2
4.0	QC5	INSPECT WORK TO CURRENT STEP		
		Comment: INSPECT WORK TO CURRENT STEP Inspect replaced rivets, as well as removed parts from the original assembly. *****Ensure no oversized holes*****		

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Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	-Pick :	
	8x MS20600AD4W2 M <u>M4747</u>	
	2x MS20600AD4W3 M <u>M18071</u>	
	8x MS20470AD4-5 M <u>M104156</u>	
	- Reassemble D2410 as per Dwg D2410	FF 07-10-23
6.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	<u>07/10/23 (2)</u>
	ensure all rivets are good	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1	<u>M105069 (2)</u>
	-Scuff WHITE AREA ONLY	
	- Re-powder coat as per dwg **** masking off the unpainted area's ****	BR 07-10-24
8.0	QC3/5	INSPECT WORK/WING WALK
	Comment: INSPECT WORK/WING WALK	<u>07-10-25 (2)</u>
9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	FF 07-10-26
	- Proceed with W/O D206-571-043 B 26886 for assembly.	(2)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<u>P 07110109 (2)</u>

Job Completion



9.5 OC 08/08/07
S 07/10/26

U 07/10/29



COPY ISSUED
BY DART

PREPARED		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA
B. Williams	APPROVED	REV. A
BW	BW	SHEET 1 OF 2
DATE		TITLE
Apr. 6, 1995		206 ASPIRATOR ASSEMBLY
A	95.04.06	NEW ISSUE
A1	RF 03.04.29	ADDED FLARE

RELEASED
1-6-95/BW

QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS2060AD4-5	RIVET CR 9163-4-2
6	MS2060AD4-5	RIVET CR 9163-4-3
17	MS2060AD4-5	RIVET CR 9163-4-4
8	MS20470AD4-5	Rivets

REFERENCE ONLY

DART

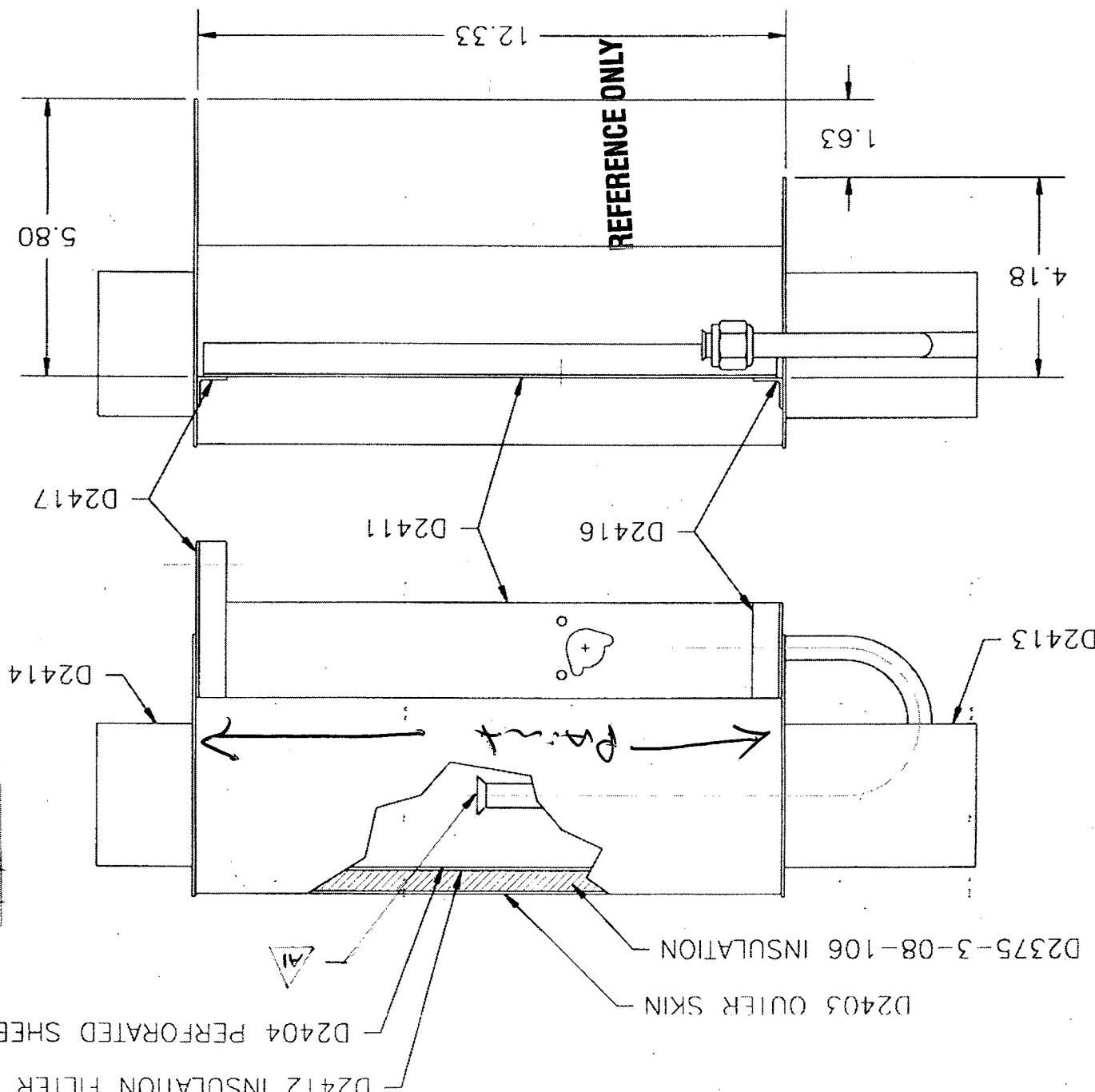
RELEASED
R [16/04/95 BLD]

PREPARED	DART AERO ACCESSORIES INC		
VICTORIA INTERNATIONAL AIRPORT, CANADA			REV. A
CHECKED	APPROVED	B.W.	SHEET 2 OF 2
DATE	Apr. 6, 1995	D2410	SCALE
TITLE			206 ASPIRATOR ASSEMBLY

D2412 INSULATION FILTER
D2404 PERFORATED SHEET

D2403 OUTIER SKIN

D2375-3-08-106 INSULATION



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/10/22	5	Replaced insulation on both heatshields. D 2375-3-08 (m10410)		Destroyed both insulation	FF 07/10/22				
07/10/22	5	Replaced ms 20600 AD4W3 with CR 32434-4 (m104252)	QS1012			07-10-23	QS1012	10-10-23	
07/10/22	5	Replaced outer skin D 2403 with new one D 2403 (B 26904) 12 CR 32434-4 (m104252)	QS1012	destroyed old ones	{ FF 07/10/23 07-10-23	QS1012	10-10-23		
07-10-23	S.O.	4 CR 3243-4-2 (m102601) PC Champs dented material. The hole was oversized on the D2411.on 7 ASS'Y, when the rivet was removed. 1 more D2411 B24398 scrap	QS1012	Replace D2411 B24398 Qty 1, and re-assemble.	B25066 07-10-23	QS1012	10-10-23		

NOTE: Date & initial all entries